CLAIMS

1. A process for the preparation of a compound of Formula (1):

Formula (1)

wherein:

R^x is optionally substituted aryl; and

R^y is optionally substituted hydrocarbyl:

which comprises the steps:

(a) reducing a compound of Formula (2):

Formula (2)

to a compound of Formula (3):

Formula (3)

wherein R^x and R^y are as defined for Formula (1):

(b) reacting a compound of Formula (3) with a leaving group donor, to give a compound of Formula (4);

Formula (4)

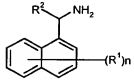
wherein:

R^x and R^y are as defined for Formula (1); and

OL is a leaving group:

(c) reacting a compound of Formula (4) with ammonia to give a compound of Formula (1).

2. A process according to claim 1 for the preparation of a compound of Formula (5):



Formula (5)

wherein:

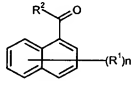
R^1 is a substituent;

R^2 is optionally substituted hydrocarbyl; and

n is 0 to 4:

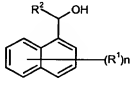
which comprises the steps:

(a) reducing a compound of Formula (6):



Formula (6)

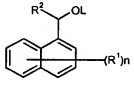
to a compound of Formula (7):



Formula (7)

wherein R^1, R^2 and n are as defined for Formula (5):

(b) reacting a compound of Formula (7) with a leaving group donor, to give a compound of Formula (8);



Formula (8)

wherein:

R^1, R^2 and n are as defined for Formula (5);

OL is a leaving group:

(c) reacting a compound of Formula (8) with ammonia to give a compound of Formula (5).

3. A process according to claim 2 where R^2 is optionally substituted C_{1-4}alkyl.

4. A process according to claim 3 where R^2 is methyl.

5. A process according to any one of the preceding claims wherein n is 0.

6. A process according to any one of the preceding claims where step (a) is carried out in the presence of a catalyst.

7. A process according to claim 6 where the catalyst is of Formula (A):

Formula (A)

wherein:

R^3 represents a neutral optionally substituted hydrocarbyl, a neutral optionally substituted perhalogenated hydrocarbyl, or an optionally substituted cyclopentadienyl ligand;

A represents $-NR^4$-, $-NR^5$-, $-NHR^4$, $-NR^4R^5$ or $-NR^5R^6$ where R^4 is H, $C(O)R^6$, SO_2R^6, $C(O)NR^6R^{10}$, $C(S)NR^6R^{10}$, $C(=NR^{10})SR^{11}$ or $C(=NR^{10})OR^{11}$, R^5 and R^6 each independently represents an optionally substituted hydrocarbyl, perhalogenated hydrocarbyl or an optionally substituted heterocyclyl group, and R^{10} and R^{11} are each independently hydrogen or a group as defined for R^6;

B represents -O-, -OH, OR^7, -S-, -SH, SR^7, $-NR^7$-, $-NR^8$-, $-NHR^8$, $-NR^7R^8$, $-NR^7R^9$, $-PR^7$- or $-PR^7R^9$ where R^6 is H, $C(O)R^9$, SO_2R^9, $C(O)NR^9R^{12}$, $C(S)NR^9R^{12}$, $C(=NR^{12})SR^{13}$ or $C(=NR^{12})OR^{13}$, $R^7$and R^9 each independently represents an optionally substituted hydrocarbyl, perhalogenated hydrocarbyl or an optionally substituted heterocyclyl group, and R^{12} and R^{13} are each independently hydrogen or a group as defined for R^9;

E represents a linking group;

M represents a metal capable of catalysing transfer hydrogenation; and

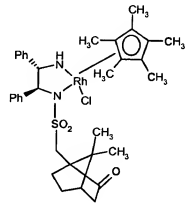
Y represents an anionic group, a basic ligand or a vacant site;

provided that when Y is not a vacant site that at least one of A or B carries a hydrogen atom.

8. A process according to claim 7 wherein A-E-B, R^3 and Y are chosen so that the catalyst is chiral.

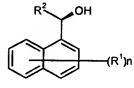
9. A process according to either claim 7 or claim 8 wherein M, the metal, is rhodium present in valence state III and R^3 is an optionally substituted cyclopentadienyl ligand.

10. A process according to any one of claims 7 to 9 where the catalyst of Formula (A) is of formula:



11. A process according to any one of the preceding claims wherein step (a) is a stereospecific reaction.

12. A process according to any one of the preceding claims wherein the product of step (a) is a compound of Formula (9):



Formula (9)

wherein:

R^1 is a substituent;

R^2 is optionally substituted hydrocarbyl; and

n is 0 to 4.

13. A process according to any one of claims 1 to 5 where in step (b) the leaving group donor is a compound of formula $R^{14}SO_2X$, where R^{14} is an optionally substituted

alkyl, optionally substituted aryl or an optionally substituted heteroaryl group and X is a halogen.

14. A process according to claim 13 where in step (b) the leaving group donor is methanesulphonyl chloride.

15. A process according to either claim 1 or claim 2 for the preparation of a compound of Formula (10):

Formula (10)

which comprises the steps:

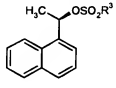
(a) reducing a compound of Formula (11):

Formula (11)

to a compound of Formula (12):

Formula (12)

(b) reacting a compound of Formula (12) with a compound of formula R^3SO_2X, in the presence of a base, to give a compound of Formula (13);



Formula (13)

wherein:

R^3 is optionally substituted C_{1-4}alkyl; and

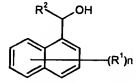
X is halogen:

(c) reacting a compound of Formula (13) with ammonia to give a compound of Formula (10).

16. A process according to claim 15 where step (a) is carried out in the presence of a catalyst of Formula (A) as described in claim 7.

17. A process according to claim 15 wherein the compound of Formula (10) is purified by diastereomeric salt resolution using (L)-tartaric acid or (L)-chloropropionic acid.

18. A process for the preparation of a stereoisomer of a compound of Formula (14):



Formula (14)

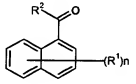
wherein:

R^1 is a substituent;

R^2 is optionally substituted hydrocarbyl; and

n is 0 to 4:

which comprises the transfer hydrogenation of a compound of Formula (6):



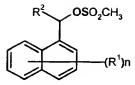
Formula (6)

by a hydrogen donor in the presence of a catalyst of Formula (A) as described in claim 7.

19. A process for the diastereomeric salt resolution of (S)-1-naphthylethylamine which comprises mixing (S)-1-naphthylethylamine with (2R,3R)-tartaric acid or (S)-chloropropionic acid to form the corresponding diastereomeric salt.

20. A diastereomeric salt of (S)-1-naphthylethylamine with (2R,3R)-tartaric acid or (S)-chloropropionic acid.

21. A compound of Formula (15):



Formula (15)

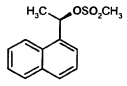
wherein:

R^1 is a substituent;

R^2 is optionally substituted hydrocarbyl; and

n is 0 to 4.

22. A compound according to claim 21 of Formula (15) which is of Formula (16):



Formula (16)